

Work Order ID 152471

Monday, October 24, 2016 11:41:52 AM

152471

Page 1

Item ID: D119-796-151

Accept

N900040100Setup Start ***NS1***

Revision ID:

Stop ***NS2***

Item Name: FWD Crosstube Installation with Step (no hardware)

Start Date: 10/31/2016 Start Qty: 1.00 ***1***

Cust Item ID:

Required Date: 11/24/2016 Req'd Qty: 1.00 ***1***

Customer:

Reference:

Approvals: Process Plan: DAS Date: **OCT 25 2016**

Tooling:

Date:

Run Start ***NR1***QC: 21
9-29

Date: SPC (Y/N):

Date:

Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
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Draw Nbr	Revision Nbr
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D119-796-151	D
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110 Document Control

0.00

110

DC

Memo

0.00

Doc.Control -USB or Paperwork

Photocopy bluefile and create labels as per PPP D119-796-151 chg 004

N/A

120 Pick Kit
Packaging

0.00

120

Packaging

Memo

0.00

Packaging

/

16-12-12

130 Crosstubes

0.00

130

Crosstubes

Memo

0.11

Crosstubes

1- Install step and clamp with the proper position per dwg D119-796-151

Torque all clamps to 50 IN-LBS max.

/

16-12-12

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____		DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐		AGAINST DEPARTMENT/PROCESS <table style="width:100%; border: none;"> <tr> <td style="border: none;">Skid-tube ☐</td> <td style="border: none;">Cross tube ☐</td> <td style="border: none;">Water Jet ☐</td> <td style="border: none;">Engineering ☐</td> </tr> <tr> <td style="border: none;">Machining ☐</td> <td style="border: none;">Small Fab ☐</td> <td style="border: none;">Prod. Eng. Coord. ☐</td> <td style="border: none;">Quality ☐</td> </tr> <tr> <td style="border: none;">Thermoforming ☐</td> <td style="border: none;">Finishing ☐</td> <td style="border: none;">Rec/Store/Packaging ☐</td> <td style="border: none;">Other ☐</td> </tr> <tr> <td style="border: none;">Large Fab ☐</td> <td style="border: none;">Composite ☐</td> <td style="border: none;">Supplier ☐</td> <td></td> </tr> </table>						Skid-tube ☐	Cross tube ☐	Water Jet ☐	Engineering ☐	Machining ☐	Small Fab ☐	Prod. Eng. Coord. ☐	Quality ☐	Thermoforming ☐	Finishing ☐	Rec/Store/Packaging ☐	Other ☐	Large Fab ☐	Composite ☐	Supplier ☐	
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		OTHER : ☐																							

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Page 2

Item ID: D119-796-151

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N900040100

Setup Start

NS1

Revision ID:

Stop

NS2

Item Name: FWD Crosstube Installation with Step (no hardware)

Start Date: 10/31/2016 Start Qty: 1.00 ***1***

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Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

Run Start

NR1

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Stop

NR2

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
140	QC5- Inspect part completeness to step on W/O	0.00				1			DAS 38 3-89
140									
QC	Memo	0.00							
Quality Control	***RE-CHECK TORQUE ON CLAMP AS PER DWG.***								DEC 17 2016
	***VERIFY BY <u>152471</u> ³⁸ ₉₋₈₉ BATCH # TO MATCH W/O								
	***VERIFY BY <u>152471</u> ³⁸ ₉₋₈₉ PART # TO MATCH								
	W/O <u>152471</u> ³⁸ ₉₋₈₉								
150		0.00							
150	Packaging					1			<u>16-12-12</u>
Packaging	Memo	0.00							
Packaging	Identify and pack for shipping as per PPP D119-796-151								
160	QC21- Final Inspection - Work Order Release	0.00							16/12/13
160									
QC	Memo	0.02							
Quality Control									

16-12-12

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Picklist Print

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Page 1

Work Order ID: 152471

152471

Parent Item: D119-796-151

D119-796-151

Parent Item Name: FWD Crosstube Installation with Step (no hardware)

Start Date: 10/31/2016

Required Date: 11/24/2016

Start Qty: 1.00

Required Qty: 1.00

Comments: IPP REV:A 14.09.09 NEW ISSUE DD VERF:JLM IPP
REV:B 14.11.19 AS PER REV.C DD VERF:JLM IPP REV:C
14.12.09 AS PER REV.PC6 DD VERF:JLM IPP REV :D 15-02-11
AS PER REV D JLM VERIFIED BY:DD

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
D119-796-141		Manufactured	No				Each	0.0000		1	DAS 41 9-89	16-12-4	
D119-796-141					152457				**	1			
FWD Crosstube Installation without Step (no hardware)													
D5123-3		Manufactured	No				Each	118.0000		4	DAS 41 9-89	16-12-4	
D5123-3									**				
Clamp Cushion													
				<u>Location</u>		<u>Loc Qty</u>	<u>Loc Code</u>						
				LG055		118							
				149113		8							
				149671		12							
				150315		48							
				151097		50				4			
D5149-041		Manufactured	No				Each	2.0000		2			
D5149-041									**				
Fwd Step Base Assembly										2			
				<u>Location</u>		<u>Loc Qty</u>	<u>Loc Code</u>						
				LG055	151787	2							
				148204		2							
MS21920-22		Purchased	No				Each	82.0000		4	DAS 41 9-89	16-12-4	
MS21920-22									**				
Clamp													
				<u>Location</u>		<u>Loc Qty</u>	<u>Loc Code</u>						
				LG050		82							
				M135544		32				2			
				M135603		50				2			

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

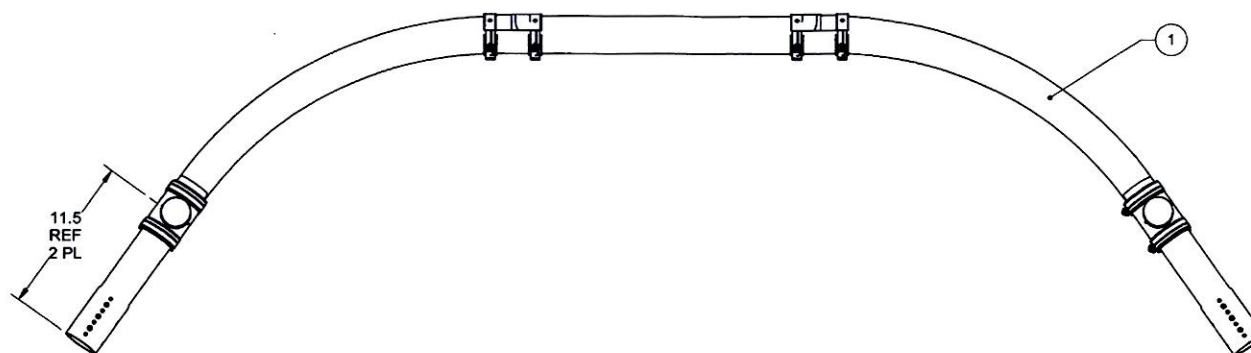
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ITEM	QTY	P/N	DESCRIPTION
	X	D119-796-151	XTUBE ASSY (AW119 MKII FWD)
1	1	D119-796-141	XTUBE ASSY (AW119 MKII FWD)
2	4	D5123-3	CUSHION
3	2	D5149-041	FWD STEP ASSEMBLY
4	4	MS21920-22	CLAMP

SHOP COPY
RETURN TO
ENGINEERING
UNCONTROLLED COPY
SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER
NO. 152471 MLC
10/10/25



D119-796-151 XTUBE ASSY (AW119 MKII FWD)

RELEASED

2015 FEB 09

ECN 15-516

NOTES:

- 1) MATERIAL: N/A
- 2) FINISH: NONE
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: N/A
- 6) IDENTIFICATION: IDENTIFY PER DART QSI 044 METHOD 6.5
- 7) WEIGHT: 19.87 lbs
- 8) TORQUE MS21920-22 CLAMPS TO 50 IN-LBS MAX
- 9) LOCATE STEP USING POST FITTING ON CROSSTUBE

D	D5123-3 CLAMP CUSHION WAS D5123-9 CLAMP CUSHION. MS21920-22 WAS -24.	AP	15.01.19
C	RE-DESIGN STEP INSTALLATION	DB	14.11.24
B	D5149-043 WAS D5149-041, AN4C6A WAS AN4C10A, D2274 WAS D5153-1	AP	14.11.04
A	NEW ISSUE	AP	14.09.03
REV.	DESCRIPTION	BY	DATE
DESIGN	AP	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
DRAWN	AP		
CHECKED	DB	DRAWING NO.	REV. D
MFG. APPR.	JLM	D119-796-151	SHEET 1 OF 1
APPROVED	HS	TITLE	SCALE
DE APPR.	DS	XTUBE ASSY (AW119 MKII FWD)	NTS
DATE	15.01.19	COPYRIGHT © 2014 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.	